

SIT IP TODAY OR 2MORROW

Work Order ID 53447

November 05, 2009 1:34:44 PM



Page 1

Item ID: D412-698-023
Revision ID: E
Item Name: Automatic Door Opener, LH/RH

Accept



Setup Start



Stop



Start Date: 11/5/2009 Start Qty: 5.00
Required Date: 11/5/2009 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MF Date: 09-11-05 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-698	Rev E

100
DOCUMENT CONTROL
0.00
Memo
Photocopy bluefile & type labels per PPP D412-698-023

CHG002

501/1/06

for BG 09/11/05

110
Pick Kit
0.00
Memo
Packaging

9/11/5 (5x) 50

120
QC4- 100% Inspect kits for completeness
0.00
Memo
Quality Control

2) 501/1/06

(5x) /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53447

November 05, 2009 1:34:44 PM



Page 2

Item ID: D412-698-023

Accept



Setup Start



Revision ID: E

Stop



Item Name: Automatic Door Opener, LH/RH

Start Date: 11/5/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 11/5/2009 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: _____								
	Rev: _____								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

09/11/10 (5)

09/11/10

MF 09-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 05, 2009 1:34:43 PM

Page 1

Work Order ID: 53447

Parent Item: D412-698-023RevE

Parent Item Name: Automatic Door Opener, LH/RH

Comments:

Start Date: 11/5/2009

Required Date: 11/5/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD516L



Washer

Purchased

No

120

Each

225.0000

10.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

225

112466

200

14477

22

17619

3

D3552-11RevD



Door Prop

Manufactured

No

120

Each

29.0000

5.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

42606

6

46631

3

52940

20

D3594-043RevB



Floor Doubler Assembly, LH

Manufactured

No

120

Each

12.0000

5.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

48255

12

11/24/09 6p
11/4/09 4p

48286 5x 50

3x 50

48255

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 05, 2009 1:34:43 PM

Work Order ID: 53447



Parent Item: D412-698-023RevE



Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 11/5/2009

Required Date: 11/5/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3594-044RevB Manufactured No

120

Each

10.0000

5.0000



Floor Doubler Assembly, RH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

48256

10

120

Each

12.0000

5.0000



D3594-5RevB

Door Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST234A

12

50115

12

120

Each

29.0000

10.0000



D3622-1RevA

Ball Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

52287

29

9/11/6 (E)

78256

9/11/5 SP

5x SP

9/11/5 SP

10x SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Bicklist Print

November 05, 2009 1:34:43 PM

Page 3

Work Order ID: 53447

Parent Item: D412-698-023RevE

Parent Item Name: Automatic Door Opener, LH/RH


Start Date: 11/5/2009

Required Date: 11/5/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-4  Rivet		Purchased	No			120	Each	3,010.000	10.0000		9/11/5	SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3010

15541

3010

120

Each

29.0000

5.0000

10x SP

9/11/5

SV SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29

111126

9

112314

20

5x SP

MS21073L5



nut plate

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	(1	D3552-11.7	GAS SPRING
	/ 1	D3594-5	DOOR DOUBLER
	/ 1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	/ 1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	/ 2	D3622-1	BALL STUD
	4	MS21073L5	ANCHOR NUT
	(2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	(2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

53447